

Date: Monday, 3/26/2007 3:23:19 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG
Job Number	: 31485B			
Estimate Number	: 10841			
P.O. Number	: N/A		Part Number	: D22493
This Issue	: 3/26/2007	S.O. No. : N/A	Drawing Number	: D2249 REV. E
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A		Drawing Revision	: E
Previous Run	: 31031B		Material	: N/A
Written By			Due Date	: 4/10/2007
Checked & Approved By			Qty:	4
Comment	Um: Each Est: D 05.02.04 Added Step 9 KJ/RF Est Rev:E Now On Waterjet 07-03-08 JLM			

Additional Product

Job-Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
		Comment: Qty.: 0.1470 sf(s)/Unit Total : 0.5880 sf(s) 304/316 .063 Sheet	
		Batch: M103961	SAD 07/04/14 (4)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2249	
		Dwg Rev: E	
		Prog Rev: E	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/04/14 (4)
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	MS 07/04/15 (4)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D2249	FE 07/04/14 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:23:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31485B

Part Number: D22493

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



3/27/07/24 (4)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5721

3/27/07/25 (4)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

3/27/07/25 (4)

Job Completion



3/27/07/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

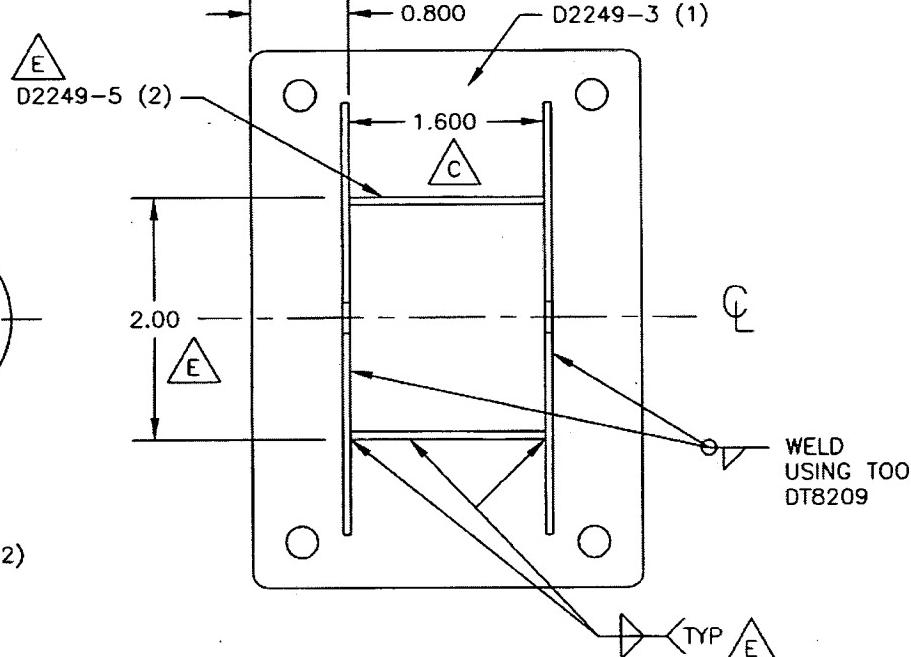
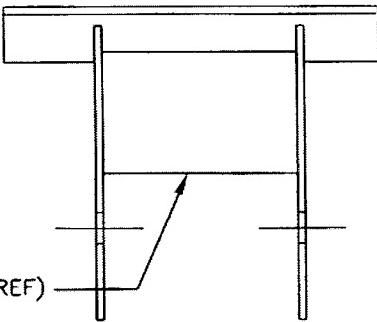
NOTE: Date & initial all entries

DART**RELEASED**

99.10.12 KE

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED W	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	SHEET 1 OF 4
		SCALE NTS

- A 94.06.20 NEW ISSUE
 B 95.11.30 DIMENSION CHANGE
 C 95.12.14 DIMENSION CHANGE
 D 98.04.30 ϕ 0.261 WAS ϕ 0.257 (TSR A179)
 REMOVED DUPLICATE DIMENSIONS
 E 99.09.20 ADDED GUSSET

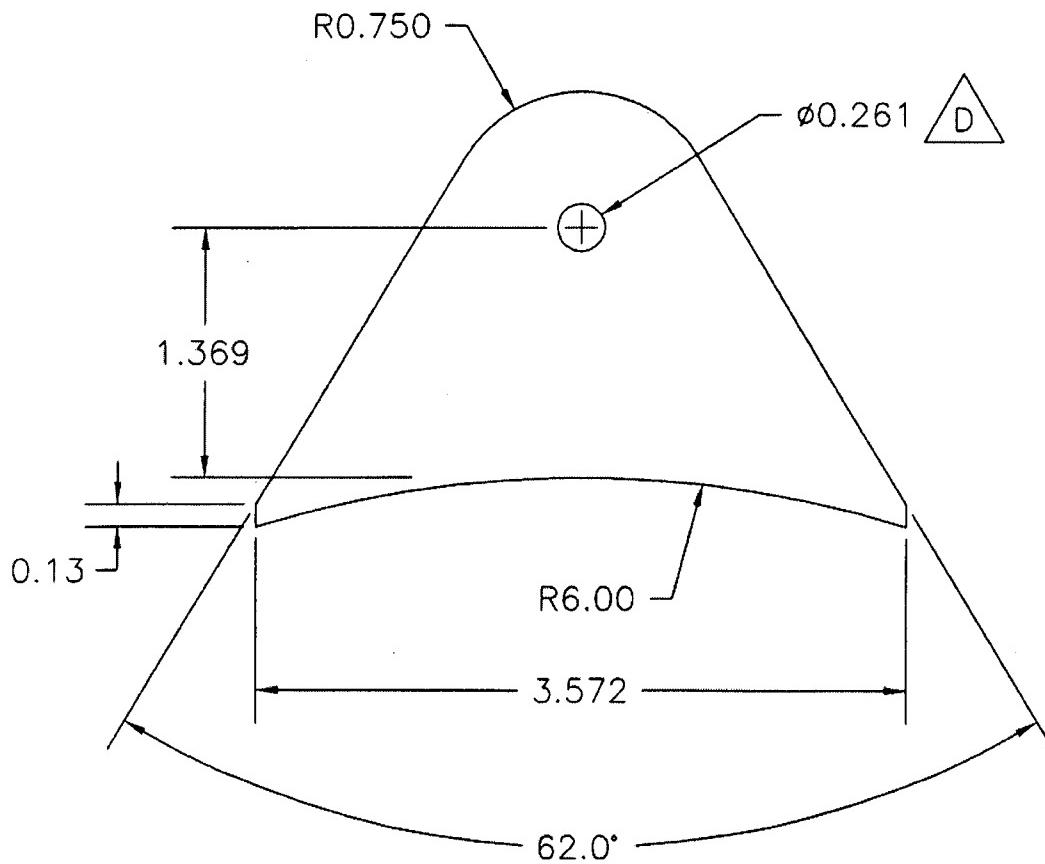
**D2249-041 ASSEMBLY**

MATERIAL: AISI 304/316 SS, 0.063 THICK
 WELD PER DART QSI 004
 FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 ALL DIMENSIONS ARE IN INCHES
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 31485B

DARTCOPY ISSUED
BY DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RE</i>	APPROVED <i>SH</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KED2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

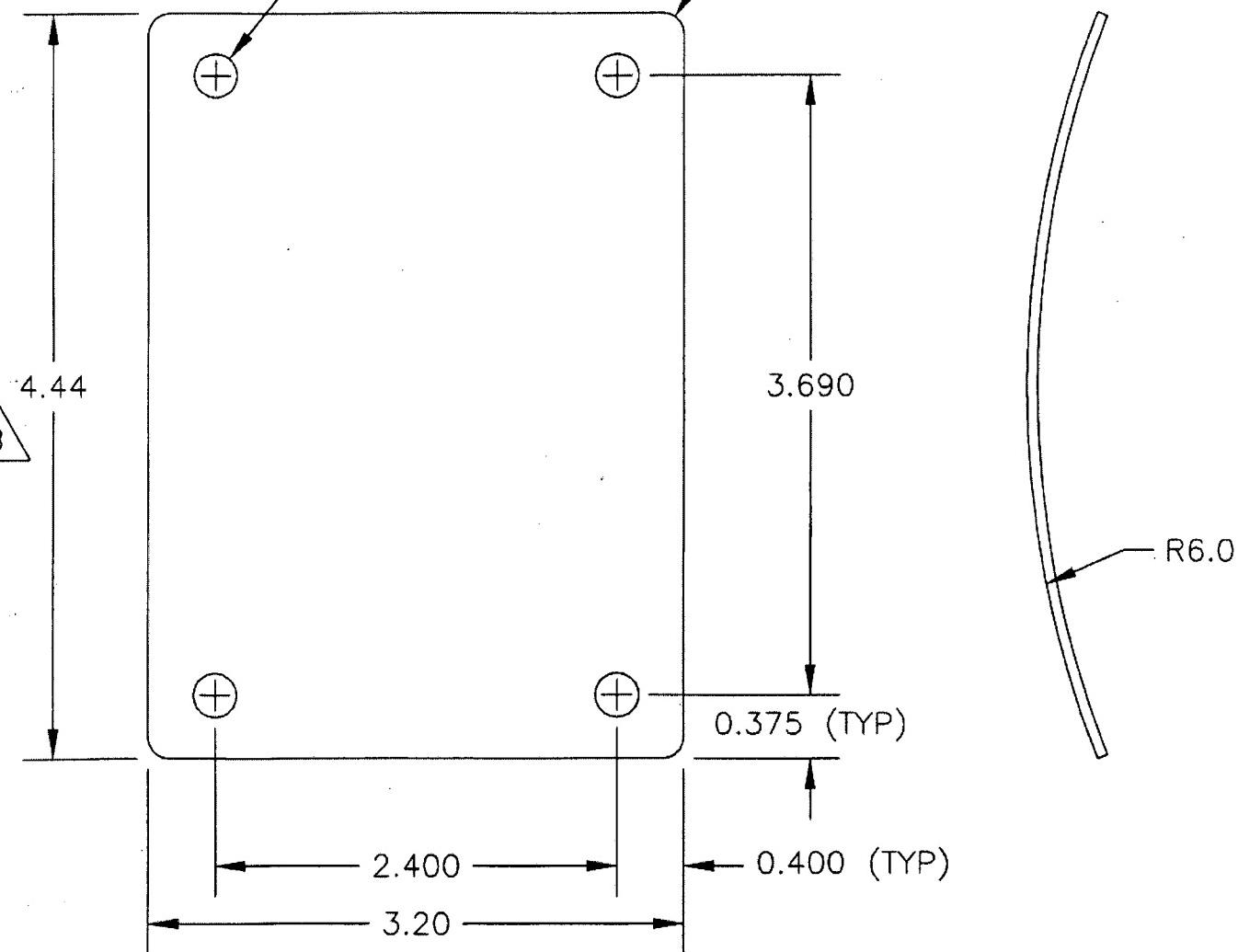
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WITHOUT NOTICE
WORK ORDER
NO. *31485B*

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>M</i>	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 3 OF 4 SCALE 1:1

RELEASED
(99.10.12 KE)

Ø0.261 (TYP) D R0.125 (TYP)

FLAT PATTERND2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

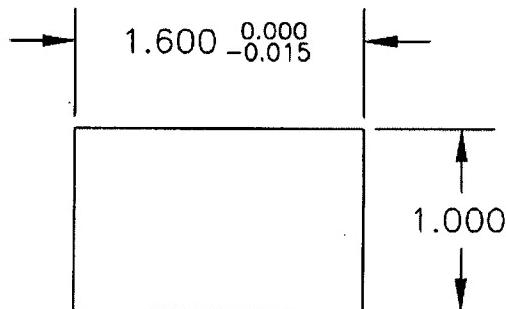
BEND DETAIL
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WITHOUT NOTICE
WORK ORDER
NO. *31485B*

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SPH</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED

49.10.12. KE

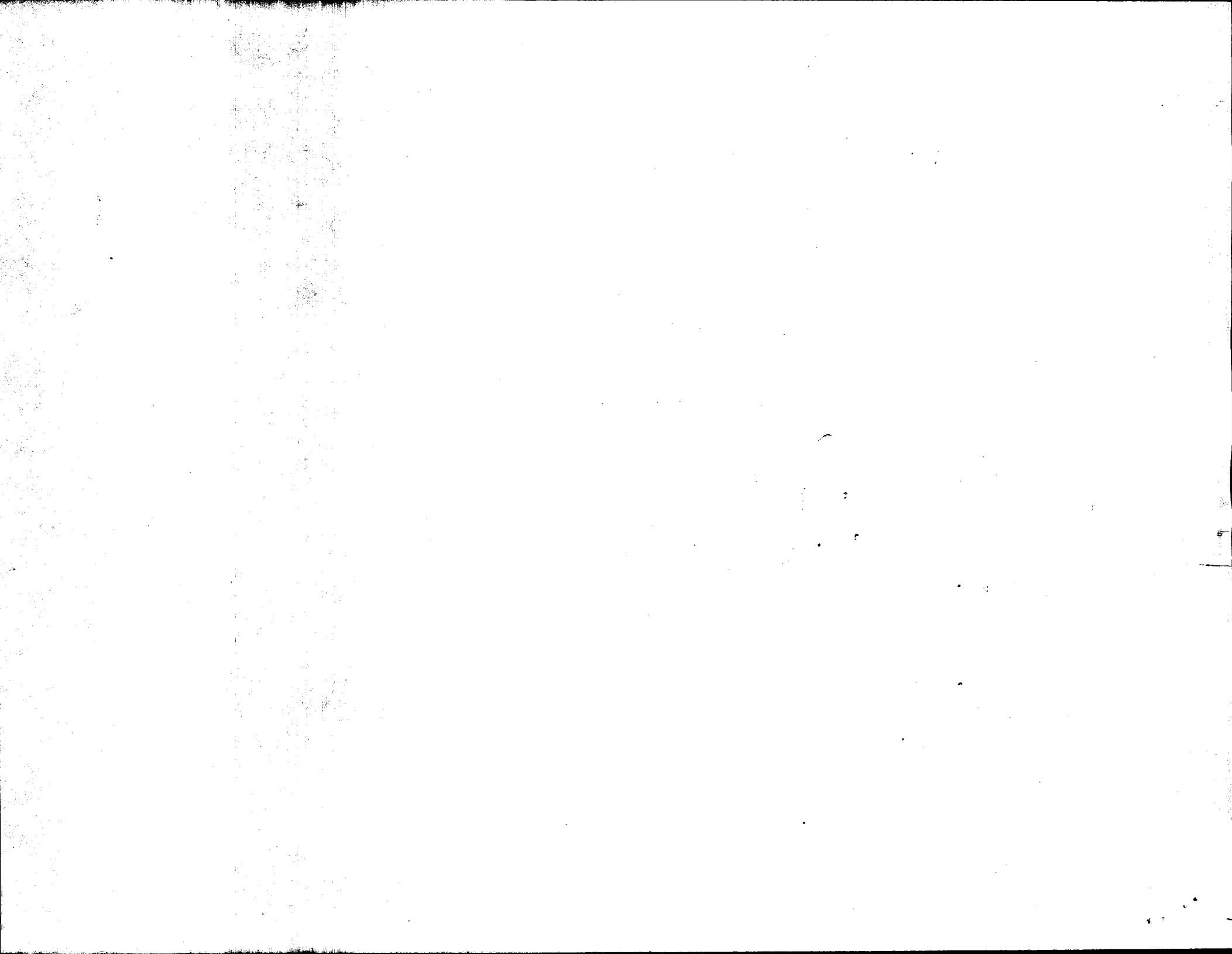
D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. *31485B*



DART AEROSPACE LTD		Work Order:	31485 B
Description:	LUG	Part Number:	D2249-3
Inspection Dwg:	D2249	Rev:	E

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 4.40	+/- 0.030	4.415	✓		Vern	
B 2.400	+/- 0.010	2.406	✓		Vern	
C 3.20	+/- 0.030	3.21	✓		Vern	
D 0.400	+/- 0.010	0.405	✓		Vern	
E 0.375	+/- 0.010	0.379	✓		Vern	
F 3.690	+/- 0.010	3.694	✓		Vern	
G Ø0.261	+0.006 -0.000	Ø0.262	✓		Vern	
H 0.067	+/- 0.010	0.058	✓		Vern	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	SAD	Audited by:	MS	Prototype Approval:	N/A
Date:	07/04/14	Date:	07/04/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	